

Work Order ID 53176

Page 1

October 26, 2009 9:03:47 AM

Item ID: D3173-041

Accept



Setup Start



Revision ID: B

Stop



Item Name: Beam Assembly

Start Date: 26/10/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 10/11/2009 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: RL Date: 09/10/26 Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3173	Rev B

100 0.00

BAND SAW

Bandsaw

Jeaspa Bandsaw

Memo

0.00

Cut blank: 56" long Machine holes as per Folio FA295 and Dwg D3173 Identify as D3173-1

MWT
09/11/13

4 *O*

110



HAAS CNC VERTICAL MACHINING #1

HAAS 1

HAAS CNC vertical machine #1

Memo

0.00

Machine holes as per Folio FA295 and Dwg D3173 Identify as D3173-1

DTX
09/11/13

4 *O*

120



QC2- Inspect parts off machine FAI/FAIB

QC

Quality Control

0.00

DTX
09/11/13

4 *O*

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Cust Item ID:

Required Date: 10/11/2009 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC8- Inspect parts - second check

0.00

SF 09/11/16

4

0

QC

Memo

0.00

140

Small Fab

0.00

Small Fab

Memo

0.00

Small Fab

1-Drill Ø0.316" holes as per Dwg D3173 2-C'sink holes as per Dwg
D3173 3-deburr-7 M/L 09/11/18

150

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

SF 09/11/23

Work Order ID 53176

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Item Name: Beam Assembly

Start Date: 26/10/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 10/11/2009 Req'd Qty: 4.00



Customer:

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:
	QC:	Date:	SPC (Y/N):	Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC3- Inspect Part Finish	0.00 <i>OK 10-11-24</i>				<i>(4)</i>			
QC	Memo	0.00							
Quality Control									

200		0.00
	Small Fab	
Small Fab	Memo	0.00
Small Fab	Assemble per Dwg D3173. <input type="checkbox"/> Install Mounting Lug as per Dwg D3173. D3175-041 is included in K10017 BOM.	

EP 09/11/30 (4)

210	QC5- Inspect part completeness to step on W/O	0.00
	Memo	0.00
QC	<i>2) 8081u120</i>	
Quality Control		

(4) - 9

Work Order ID 53176

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October 26, 2009 9:03:48 AM

Item ID: D3173-041

Accept



Setup Start



Revision ID: B

Stop



Item Name: Beam Assembly

Start Date: 26/10/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 10/11/2009 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220 	Identify as per dwg & Stock Location: <u>518</u>	0.00							<u>gl460</u> <u>40</u> <u>sf</u>
Packaging	Memo	0.00							

230 	QC21- Final Inspection - Work Order Release	0.00							<u>09/11/30</u> <u>J</u>
QC 	Memo	0.00							

PL 09/11/30
(4)

Picklist PrintPage 1
B

October 26, 2009 9:03:51 AM

Work Order ID: 53176



Parent Item: D3173-041RevB



Parent Item Name: Beam Assembly

Start Date: 26/10/2009

Required Date: 10/11/2009

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21042L5		Purchased		No		100	Each	1,077.000	8.0000		<i>8/30/11/30</i>	

Nut

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

ST	1077	
110382	10	
111127	4	
111636	63	
112314	1000	

D3178-041RevA

Manufactured

No

170 Each 18.0000 8.0000



Nut Plate

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

ST	18	
24895	10	
25298	8	

8/30/11/30
2
6

Picklist Print

Page 2

October 26, 2009 9:03:52 AM

Work Order ID: 53176**Parent Item:** D3173-041RevB**Parent Item Name:** Beam Assembly**Start Date:** 26/10/2009**Required Date:** 10/11/2009**Comments:****Start Qty:** 4.00**Required Qty:** 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6TR4.0X2.0W1 25		Purchased	No			170	f	6.1600	19.7368			

6061-T6 Rect Tube 4.0 x 2.0 x .125w



AN3-5A



Bolt

Purchased

No

112030

200

Each

2,249.000 32.0000



19.6875

Warehouse**Location**

Main Warehouse

MAT

6.16

109025

0.31

109088

0.36

14394

4.66

19265

0.83

Warehouse**Loc Qty****Loc Code****Location**

Main Warehouse

ST

2249

100188

188

105057

2061

32

Picklist Print

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October 26, 2009 9:03:52 AM

Work Order ID: 53176



Parent Item: D3173-041RevB



Parent Item Name: Beam Assembly

Start Date: 26/10/2009

Required Date: 10/11/2009

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

AN5-23A		Purchased	No			200	Each	23.0000	8.0000		E/S 09/11/30	
---------	--	-----------	----	--	--	-----	------	---------	--------	--	--------------	--

Bolt

WarehouseLocation

Main Warehouse

ST

Loc QtyLoc Code

23

19278

23

AN960JD10



Purchased

No

Washer

Warehouse	Loc Qty	Loc Code
-----------	---------	----------

WarehouseLocation

Main Warehouse

ST

Loc QtyLoc Code

1897

105442
109059
109840
110985
111279
111668
112314
112369

95

23

202

5

64

1000

506

32

oops my bad
all good

Picklist Print

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October 26, 2009 9:03:52 AM

Work Order ID: 53176



Parent Item: D3173-041RevB



Parent Item Name: Beam Assembly

Start Date: 26/10/2009

Required Date: 10/11/2009

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD516  Washer		Purchased	No			200	Each	1,595.000	16.0000		 EF30814/30	

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	1595	
100564	2	
106167	6	
107534	34	
107959	43	
108246	46	
108672	2	
109059	49	
109752	22	
110363	45	
110523	57	
111279	39	
112082	68	
12314	500	
12794	181	
12828	500	

"oops my bad"
all good

Picklist Print

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October 26, 2009 9:03:52 AM

Work Order ID: 53176



Parent Item: D3173-041RevB



Parent Item Name: Beam Assembly

Start Date: 26/10/2009

Required Date: 10/11/2009

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3175-041RevA



Manufactured

No

200

Each

6.0000

8.0000



Mounting Lug

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Main Warehouse

ST

6

25025

1

41678

5

MS20601-AD4W4



Purchased

No

200

Each

47.0000

32.0000



Rivet

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Main Warehouse

ST

47

19278

47

D3065-5DART AEROSPACE LTD	Work Order:	53176
Description: Beam	Part Number:	D3173-1
Inspection Dwg: D3173 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:		Audited by:		Prototype Approval:	N/A
Date:	09/11/15	Date:	09/11/16	Date:	N/A

Rev	Date	Change		Revised by	Approved
A	04.02.25	New Issue	P/O D3173-041	KJ/RF	PF



QA COPIES
DRAFT

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. B
		D3173	SHEET 1 OF 3
DATE	TITLE		SCALE
03.01.07	BEAM ASSEMBLY		NTS
A	02.12.03	NEW ISSUE	
B	03.01.07	REMOVE PIP PINS	

PARTS LIST

QTY	PART NUMBER	DESCRIPTION
X	D3173-041	BEAM ASSEMBLY
1	D3173-1	BEAM
2	D3175-041	MOUNTING LUG
2	D3178-041	NUT PLATE
8	AN960JD10	WASHER
4	AN960JD516	WASHER
2	MS21042L5	NUT
8	MS20601AD4W4	RIVET
8	AN3-5A	BOLT
2	AN5-23A	BOLT

NOTES

D3173-1 BEAM:

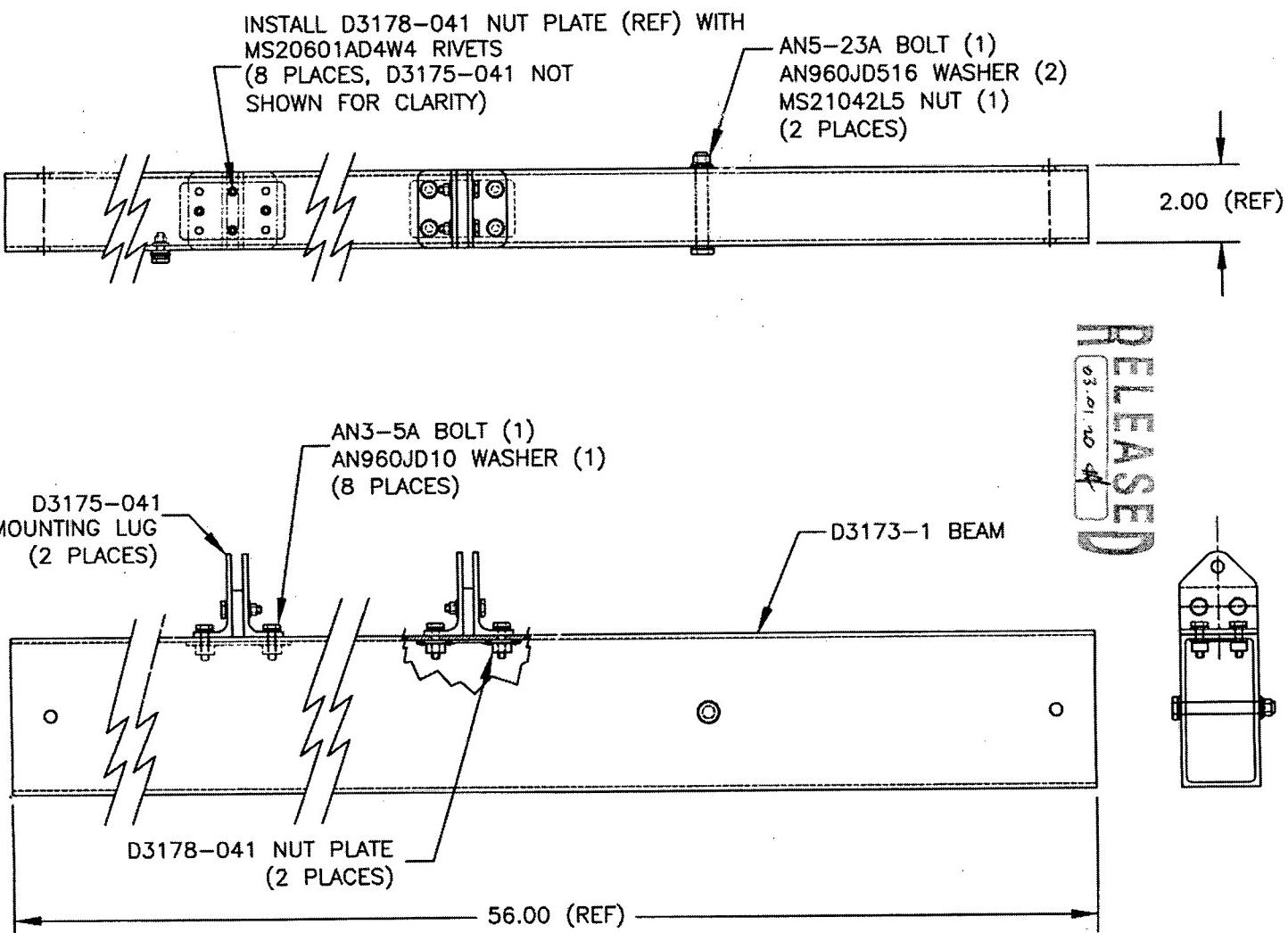
- 1) PART IS SYMMETRICAL ABOUT CENTERLINE
- 2) MATERIAL: 6061-T6 RECTANGULAR TUBING, 4" x 2" x 0.125" WALL (QQ-A-200/8)
(REF DART SPEC. M6061T6TR4.0x2.0W125)
- 3) BREAK ALL SHARP EDGES 0.010-0.020
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3 OUTSIDE ONLY
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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NO. 53176
BS 09-10-26

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03.01.07

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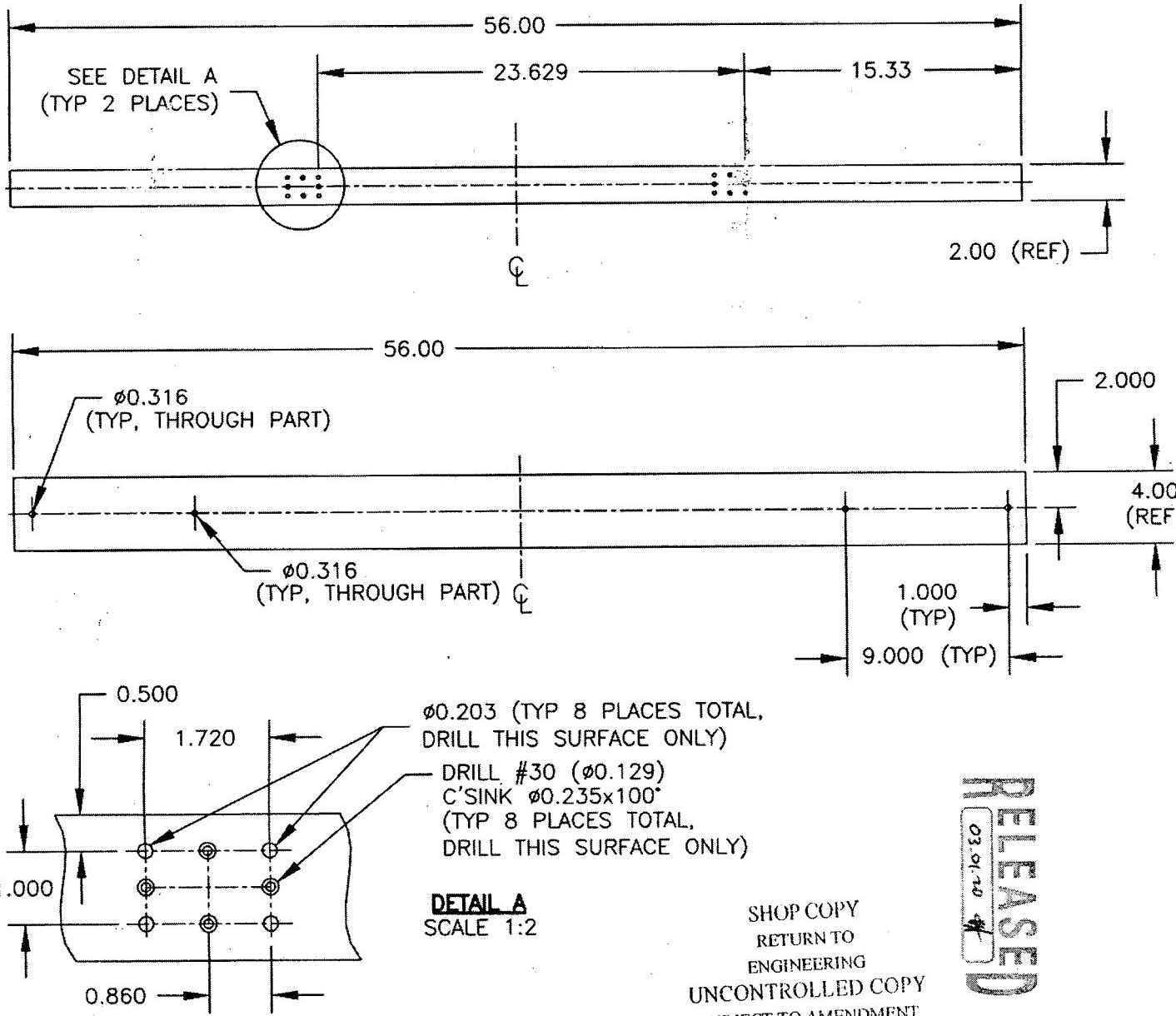
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03.01.10

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DATE	APPROVED	REV. B
03.01.07	✓	SHEET 2 OF 3
TITLE	SCALE	1:4
BEAM ASSEMBLY		



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NO. 53174

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		D3173	REV. B
DATE		TITLE	SHEET 3 OF 3
03.01.07		BEAM ASSEMBLY	SCALE 1:8

